



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

For sale

D5122-1

Job Sheet 174957



Part No: D5122-1

Job Qty: 10 ea

Part Name: Center Support, Upper



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/23/18

Job Tracking No:

Due Date: 4/12/18 *May 15*

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: DWG REV A SHEETS 1,2 IPP REV.A NEW ISSUE JFS 14/07/16 VERIFIED BY: DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea		4/11/18	0.00	0.00	Start Up Machining-3		<i>2018-07-10</i>
100	CNC Vertical Machining	10 pcs		4/12/18	0.65	18.18	HAAS1-4		<i>2018-07-10</i>
110	QC	10 pcs		4/12/18	0.00	0.00	QC2 Machining-3		<i>2018-07-10</i>
120	QC	10 pcs		4/12/18	0.00	0.00	QC8 Machining-3		<i>2018-07-10</i>
130	Packaging	10 pcs		4/12/18	0.00	0.00	Packaging3-2	<i>LG0543</i>	<i>JUL 14 2018</i>
140	QC21-SA	10 Ea		4/12/18	0.00	0.00	QC21	<i>DAS 53 9-89</i>	<i>JUL 16 2018</i>

Part Op 100 - Machine as per Folio FB324
Descriptions: 130 - LOCATION : LG054

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D5122-1TRN	Center Support, Upper, Turning Detail	5 Ea (.5 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D5122-1TRN	5	2	0

Part Specifications

Specifications could not be found.

Plex 3/23/18 10:34 AM Dart.Gagnon.Michelle



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S090238



Part: D5122-1

Job No: 174957

Serial No/Batch: S090238

Revision:

Inspector:

Exp Date:

Instructions:

Date: 07/10/18

HTO

3105 11 11P

11/11/18

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☒ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : <u>18-07-13</u>	Step #: <u>100</u>	QTY Effective : <u>①</u>		MRB (QSI042) Approval DAS 9 9-89 <u>18-07-13</u>	
Description Work Order Deviation		Disposition		Completed By Lead hand / Supervisor Approval Verification <u>18/07/13</u> QC / QA Coordinator Approval DAS 9 9-89 <u>18-07-13</u>	
<u>Note perpendicular is .001 over tolerance</u>		<u>Scrap destroy no replace</u>			
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☒ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☒ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER : _____			

DART AEROSPACE LTD		Work Order:	
Description: Center Support		Part Number:	D5122-1
Inspection Dwg: D5122	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
HAAS Section								
AA	1.782	1.202		1.194	1.194	1.194	1.194	1.194
AB	0.090	0.110		0.100	0.100	0.100	0.100	0.100
AC	0.545	0.565		0.5535	0.555	0.555	0.555	0.555
AD	3.690	3.700		3.698	3.698	3.700	3.700	3.697
AE	3.550	3.560		3.558	3.558	3.559	3.559	3.557
AF	2.453	2.473		2.465	2.465	2.465	2.465	2.465
AG	1.261	1.281		1.270	1.271	1.270	1.270	1.270
AH	0.150	0.210		0.190	0.190	0.185	0.185	0.185
AI	0.454	0.474		0.464	0.464	0.464	0.464	0.464
AJ	Ø0.260	Ø0.267		0.261	0.261	0.261	0.261	0.261
AK	Ø0.188	Ø0.194		0.190	0.190	0.190	0.190	0.190
AL	3.067	3.077		3.072	3.072	3.072	3.072	3.072
AM	3.990	4.010		4.000	4.000	4.000	4.000	4.000
AN	1.990	2.010		2.000	1.998	2.000	2.000	2.000
AO	Ø0.625	Ø0.630		0.625	0.625	0.625	0.625	0.625
AP								
AQ								
AR								
AS								
AT								
AU								
AV								
AW								
AX								
AY								
AZ								
Ensure that Ø " bore is perpendicular to " bore within "								
Accept/Reject								

Measured by: 2018 DAS	Date: 2018-07-10
Audited by: 1 KJ 9-89 <i>[Signature]</i>	Date: 18/07/13
Preliminary Approval:	Date:

Rev	Date	Change	Revised By	Approved
A	15.03.12	New Issue	KJ <i>[Signature]</i>	<i>[Signature]</i>

DART AEROSPACE LTD		Work Order:	
Description: Center Support		Part Number:	D5122-1
Inspection Dwg: D5122 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				X6	X7	X8	X9	X10
HAAS Section								
AA	1.782	1.202		1.194	1.194	1.194	1.195	1.195
AB	0.090	0.110		0.100	0.100	0.100	0.100	0.100
AC	0.545	0.565		0.555	0.555	0.555	0.555	0.555
AD	3.690	3.700		3.697	3.696	3.696	3.694	3.694
AE	3.550	3.560		3.558	3.558	3.558	3.555	3.555
AF	2.453	2.473		2.465	2.465	2.465	2.465	2.465
AG	1.261	1.281		1.270	1.270	1.270	1.271	1.271
AH	0.150	0.210		0.185	0.185	0.185	0.185	0.185
AI	0.454	0.474		0.464	0.464	0.464	0.464	0.464
AJ	Ø0.260	Ø0.267		0.261	0.261	0.261	0.261	0.261
AK	Ø0.188	Ø0.194		0.190	0.190	0.190	0.190	0.190
AL	3.067	3.077		3.072	3.072	3.072	3.072	3.072
AM	3.990	4.010		4.000	4.000	4.000	4.000	4.000
AN	1.990	2.010		2.000	2.000	2.000	2.000	2.000
AO	Ø0.625	Ø0.630		0.625	0.625	0.625	0.625	0.625
AP								
AQ								
AR								
AS								
AT								
AU								
AV								
AW								
AX								
AY								
AZ								
Ensure that Ø " bore is perpendicular to " bore within "								
Accept/Reject								

Measured by:		Date:	
Audited by:	<i>mf</i>	Date:	18/07/13
Preliminary Approval:		Date:	

Rev	Date	Change	Revised By	Approved
A	15.03.12	New Issue	KJ	<i>[Signature]</i>